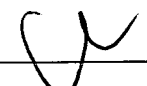


Date: Monday, 25/02/2008 11:43:57 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE BILLET (6061)
Job Number :	37601		
Estimate Number :	11989		
P.O. Number :		Part Number :	D6102011
This Issue :	25/02/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D6102 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :		Due Date :	26/02/2008
Comment :	Est. A 04.08.19 New issue KJ/JLM		

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: 5788

08/02/25

- a) Description: Aluminum Billet
 - b) 6.500" x 8.250" x 2.500" thick
 - c) Tolerance on all dimensions is +0.06/0.00
 - d) Grain direction along 6.500" length
 - e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)
- Material release certificate is required

(10)

2.0	D6102011P	6061-T6 8.25x6.5x2.5
-----	-----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 6061-T6 8.25x6.5x2.5

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

08/03/3

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK
 Check certification to Dwg D6102 for compliance

08/03/07

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

08/03/07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/02/2008 11:43:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 37601

Part Number: D6102011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 08/03/07

Job Completion



mi 2008/3/07 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

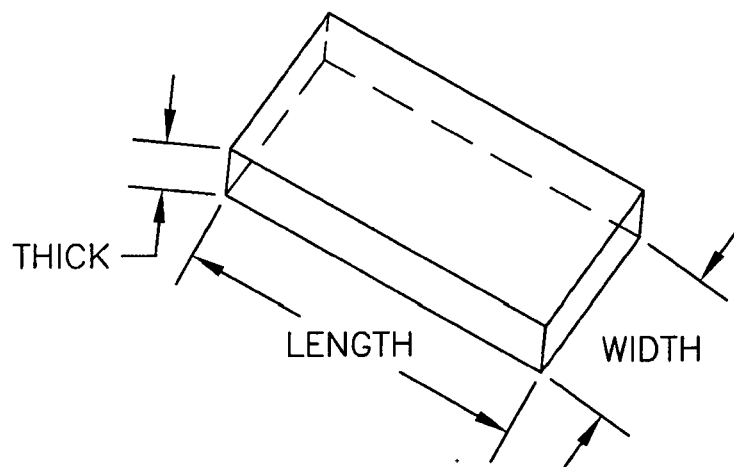
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING

**RELEASED**

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MAGNA

MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDE
SALES ORDER

0165171

ENDU À /
OLD TO:

LIVRÉ À /
SHIP TO:

INSTRUCTIONS SPECIALES / SPECIAL INSTRUCTIONS

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER		N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT CUSTOMER FAX NO.							
0165171		DART		5788		613 632-5200		632-4443							
LIVRÉ VIA - SHIP VIA		CONDITIONS - TERMS		DATE COMMANDEE DATE ORDERED		DATE REQUISE DATE REQUIRED		DATE LIVREE DATE DELIVERED							
NIR:R-557065-1		NET 30		Feb-25-08		Feb-29-08		15 26 EB							
CONTROLE DE QUALITE DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D <input type="checkbox"/>				CONTROLE DE QUALITE DE MAGNA REQUIS MAGNA QUALITY RELEASE REQ'D <input type="checkbox"/>				PREPAYE PREPAID <input type="checkbox"/>		A PERCEVOIR COLLECT <input type="checkbox"/>					
QUALITE - QUALITY COMMANDEE ORDERED		A VENIR - B/O		UNITE UNIT		N° DE COULEE HEAT NUMBER		DESCRIPTION		QTE LIVREE QTY SHIPPED		PRIX PAR PRICE PER		INSTRUCTIONS DE L'USINE PLANT INSTRUCTIONS	
10				pcs		BMA13		6061-T6 8.25 X 7.95 X 2 1/2" GRAIN TO RUN ALONG 7.95						10 pcs 66496	
10				pcs		BMA13		8.25 X 6.5 X 2 1/2" GRAIN TO RUN ALONG 6.5 SPEC QQ-A-250/11						10 pcs 66498	
								TOTAL :						LBS	

NOMBRE DE PAQ.
NUMBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER ☒

POSTE
MAIL ☐

TÉLÉCOPIEUR
FAX ☐

****PACKING SLIP / BON D'EMBALLAGE****

Page: 1
15:31:48

20080225

N° DE COULEE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END ☐

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISED 8-77/84 - FORM 2004

S.C. ALPROM S.A.	CERTIFIED SRAC-IQNet	MILL	EN 10204	No.
SLATINA	ISO 9001/2001 No. 23/2-2005	CERTIFICATE	3.1	3044

CUSTOMER :

CONTRACT/ORDER : 12612-18344-3-01
BILL OF DELIVERY : 68715
TRUCK/CONTAINER : ZCSU 2376996

ALUMINUM PRODUCTS (PLATES)

12612-18344-3-01 SHIPMENT OF 40,643.738 LBS ALUMINUM PLATES 6061-T651, MILL FINISH.
ACCORDING TO ASTM B-209-04, AMS 4027M, AMS QQA 250/11F FROM CONSTANTA ROMANIA
TO BALTIMORE, MD. L/C NO. 1144856. CFR BALTIMORE, MD.

MATERIAL : ALUMINUM PLATES

ALLOY : 6061

TEMPER: T651

DIMENSIONS (mm) : BM113 - 1 2.5000"THX48.50"WDX144.50"LT
BM176 - 1 4.0000"THX80.50"WDX144.50"LT

ACCORDING TO : ASTM B-209-04, AMS 4027 M, AMS-QQA 250/11F

MECHANICAL PROPERTIES			1 MPa = 1 N/mm2 = 0.145 ksi = 0.102 kgf/mm2							
1 lbs = 0.4536 kg			UTS		YTS		Elong. %	Hardness		
			ksi		ksi		50mm	HB		
			min.	max.	min.	max.	min.	min.		
Specified values:			42		35		6			
LOT / BATCH	CASE	NET WEIGHT lbs	Measured values:							
BM113 1	216;235;236;245;249	15,385.802	46.1		42.5		9			
BM113			46.7		42.3		9			
BM176 1	211;212;213	10,359.347	46.3		42.8		7			
6050580			44.5		40.8		9			
CHEMICAL PROPERTIES %										
BATCH	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ni	Ti	Al
BM113	0.46	0.47	0.17	0.14	0.97	0.06	0.18	0.007	0.02	REM.
6050580	0.56	0.4	0.19	0.09	1	0.08	0.054	0.003	0.016	REM.
Min.	0.4		0.15		0.8	0.04				REM.
Max.	0.8	0.7	0.4	0.15	1.2	0.35	0.25	0.05	0.15	
Cond.			Others Each: 0.05				Others Total: 0.10			

REMARKS:

We hereby certify that the material detailed hereon has been produced and tested according to the requirements of the relevant specification and/or order. Keep in dry conditions, without large temperatures variations.

Date: QUALITY CONTROL DEPT.

S.C. ALPROM S.A.

6/5/2008

S.C. ALPROM S.A.
QUALITY CONTROL DEPT.